

Wednesday, 9/12/2007 11:13:29 AM
Eric Charbonneau

Process Sheet

SPLIT

34637-2
34637-3CP
07.09.05

PROTOTYPE

FOR ENGINEERING USE ONLY

3 CP 07.09.05

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : 212 X-TUBE ,LOW NARROW FWD

Number : 34637

Part Number : D212664147

Material Number : 13018

Drawing Number : D212-664-147 U/R

Issue : 9/12/2007 S.O. No. :

Project Number : LG0009

Next Rev. : NC

Drawing Revision : U/R

Issue : / /

Type : LANDING GEAR

Material :

Due Date : 9/19/2007

Qty: 3 Um: Each

Drawn By : *BC*

Checked & Approved By :

Comment : Est Rev:A New Issue 07.09.12 EC verified by: JLM

Additional Product

Part Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-147 CHG001

N/A CP 07.08.28

2.0

D6019128

Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6019-128 Crosstube *29369*

Check OD = 2.750"; ID = 2.125"

CERTIFICATE OF CONFORMITY
REQUIRED

S.F 07/09/24

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: 1-TURN AS PER FOLIO FA705 & DWG D212-664-147,

FOLIO REV: _____

DWG REV: _____

2-DEBURR AS REQUIRED

S.F 07/09/24

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

S.F 07/09/24

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE ,LOW NARROW FWD

Job Number: 34637

Part Number: D212664147

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK

**ENGINEERING
APPROVAL**

Comment: SECOND CHECK

P. 07.09.03 (3)

6.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

JD 7-9-20 (3)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

P. 07.09.20 (3)

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-9-23 (3)

9.0 QC3/5

INSPECT WORK/WING WALK



Comment: Inspect work & Chemical conversion Coat

QC3 / QC5 P. 07.09.24 (3)

10.0 BENDING

BENDING MACHINE

BIN 34637-1 EL
7-9-24 (3)

U/SPLIT

Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

EL 7-9-25 (3)

11.0 QC6

DIMENSIONAL CHECK

**ENGINEERING
APPROVAL**

Comment: DIMENSIONAL CHECK

BIN 34637-1 P. 07.09.26 (1)

12.0 D36591

CUFF



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

CUFF

Batch:

34706^{MD}

P. 07.09.27

CERTIFICATE OF CONFORMITY
REQUIRED

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE ,LOW NARROW FWD

Job Number: 34637

Part Number: D212664147

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Rivet holes as per Dwg D212-664-147 using DT8972.

2-Drill pilot holes in tube as per Dwg D212-664-147

3-Ream hole to finish size in tube as per Dwg D212-664-147

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-147

25 07-09-22

25 07-09-21

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat Tube & Cuffs as per QSI 005 4.1

25 07-09-21

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

B/N 34637-1 25 07-09-21

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

B/N 34637-1 25 07-09-21

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: _____ LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

N/A 25 07-09-21

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

N/A 25 07-09-21

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE ,LOW NARROW FWD

Job Number: 34637

Part Number: D212664147

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

N/A 07.09.22

20.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet Cuffs as per Dwg D212-664-147. with Sika flex in Between tube & Cuff

A/R SIKAFLEX -241/-291

BATCH:

105 488

07 09-22

21.0

CR3212400-7

CHERRY RIVET



Comment: Qty.: 44.0000 Each(s)/Unit Total : 88.0000 Each(s)

CHERRY RIVET

Batch: 104 031

07 09-22

22.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

07 09-22

2-Paint outside crosstube with White Imron as per QSI 005 4.2

N/A 07.09.22

23.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

N/A 07.09.22

24.0

D28931

Support



CERTIFICATE OF CONFORMITY
REQUIRED



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Support

333560

07 09-22

Wednesday, 9/12/2007 11:13:30 AM

Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE ,LOW NARROW FWD

Job Number: 34637

Part Number: D212664147

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

D3595063450

Rubber Cushion (per sq ft)



Comment: Qty.: 0.8295 sf(s)/Unit Total : 1.6590 sf(s)

Rubber Cushion

Cut to .630" X 4.5" Qty 4

Batch: 33833

CERTIFICATE OF CONFORMITY
REQUIRED

RT 07-09-23

26.0

MS2192025

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Clamp

Batch: M104902

RT 07-09-23

27.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D212-664-147

Instal support with magnobond 6398 per dwg D212-664-147,
cure for 12hrs before packaging.

Time & date of application: 12:00

Batch: 104723

RT 07-09-23

RT 07-09-23

28.0

QC5

INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

Comment: INSPECT WORK TO CURRENT STEP

BIN 34637-1 1P 07.09.24(1)

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2

Identify and pack for shipping as per PPP D212-664-147

FOR ENGINEERING USE ONLY

N/A 07.09.24

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

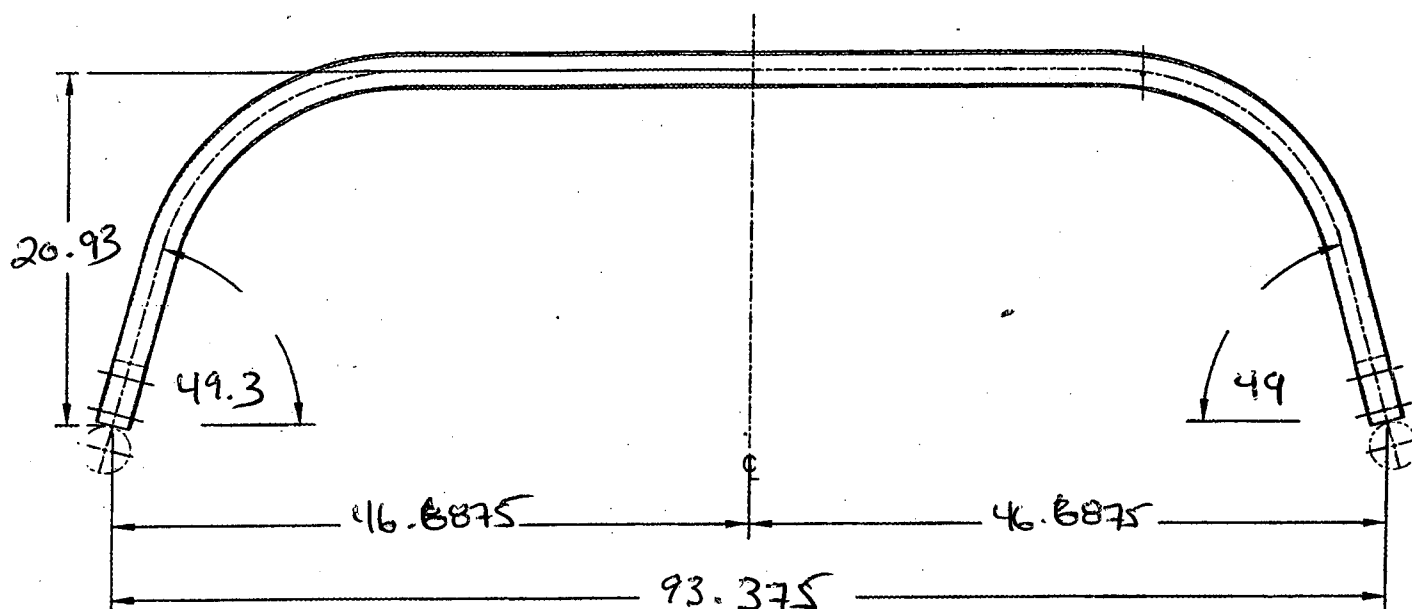
FOR ENGINEERING USE ONLY

Job Completion



DART AEROSPACE LTD	Work Order: 34637-2
Description: X-tube low 1212 FWD	Part Number:
Inspection Dwg: 0212-664-147 Rev: Prelim.	Page 1 of 1

Required Dimension	Actual	Min	Max
Height	20.92	+/- 0.13	
1/2 Span	46.68		
Angle	50°	+2° / -1°	
Total Span			



Comments

QC15 Inspection	
Date	07.09.24

07.09.24

Rev	Date	Change	Revised by	Approved
A		New Issue		
B	06.09.19	Reformat; QC level revised	KJ/JM	
C	07.02.06	Reformat	KJ/JM	

DART AEROSPACE LTD	Work Order: 800206
Description: Crosstube Assembly	Part Number: 34637B 0212-664-147-2
Inspection Dwg: 0212-664-147 Rev: 1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.673	+0.005 -0.000	2.678				
	2.573	"	2.578				
	2.473	"	2.478				
	2.366	"	2.369				
	2.360	"	2.364				
	2.750 slot	+0.020	2.750				
	126.53	+0.020	126.53				
SIDE B							
	2.673	+0.005-0.000	2.678				
	2.573	"	2.578				
	2.473	"	2.478				
	2.366	"	2.471				
	2.360	"	2.364				
	2.750 slot	+0.020	2.750				

Measured by: 88	Audited by: J.F.	Prototype Approval:	N/A
Date: 01/08/36	Date: 07/08/30	Date:	N/A
Rev	Date	Change	Revised by
A		New Issue	KJ/JLM
			Approved

DART AEROSPACE LTD		Work Order: B00206
Description: Crosstube Assembly		Part Number: 34637 L
Inspection Dwg: 0212-661-147 Rev: 1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.673	+0.005 -0.000	2.678			
	2.573	"	2.578			
	2.473	"	2.478			
	2.366	"	2.371			
	2.360	"	2.365			
	2.750 stock	+0.020	2.750			
SIDE B	2.673	+0.005-0.000	2.678			
	2.573	"	2.578			
	2.473	"	2.478			
	2.366	"	2.371			
	2.360	"	2.365			
	2.750 stock	+0.020	2.750			

Measured by: J.A.	Audited by: J.F.	Prototype Approval:	N/A
Date: 07/08/30	Date: 07/08/30	Date:	N/A
Rev A	Date	Change	Revised by
		New Issue	KJ/JLM
			Approved

12-19-71

2 3-11

12-19-71
2 3-11